Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 34467		
Estimate Number	: 10227		
P.O. Number	: N/A	Part Number	: D2151
This Issue	: 9/7/2007 S.O. No. : N/A	Drawing Number	: D2151 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 33885	Material	: N/A
		Due Date	: 9/14/2007 Qty: 20 Um: Each
Written By	:		
Checked & Approved By	: ☑ 07.09.07		
Comment	: Est C 00.10.23 Re-format (mpp 2101) EC		
	Est Rev:D 06-04-28 Manufactured on Water Jet JLM		
	Est Rev:E 06-11-24 As per Rev B JLM		

Additional Product

Job Number: |||||||||||||||||||||||||

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet

Comment: Qty.:   0.0368 sf(s)/Unit   Total :   0.7350 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040)   Batch: M105225 (1) scrap
M104025 (1) scrap

M 103321
HB 07-09-11

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D2151   HB 07-09-11
Dwg Rev: B
Prog Rev: B   (20)

2-Deburr if necessary

PTO →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-09-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK   Eo 09/04/12   (X 20) counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
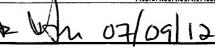
Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr   ☑ ____ 07/09/12   (20)

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes / No⃝ DQA: ⌐⌐ Date: 07/09/17

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07/09/10	2	Scrap ② port because PxF was not correct 0.250 was supose to be 0.231	✓ 051012	Scrap .destroy .replace ———— Fix Dxf "program"	JAO 07/09/10 ✓ 07-09-10	Er 07/09/11	✓ 051012	Er 07/09/16

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** DOUBLER

Job Number: 34467 **Part Number:** D2151

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 *BR 07-09-13*

7.0	POWDER COATING	POWDER COATING

m 07 09 14

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

09.09.14 20

Comment: INSPECT POWDER COAT

9.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____ *5717* *07/8/14 20*

10.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE *07/09/17*

Job Completion *CL 07/09/17.*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34467
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | | Prototype |

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.098	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.171	✓		Vern	
0.231	+/-0.010					
1.217	+/-0.010	1.217	✓		Vern	
2.194	+/-0.010	2.193	✓		Vern	
2.300	+/-0.010	2.304	✓		Vern	
1.560	+/-0.010	1.569	✓		Vern	
0.250	+/-0.010	0.253	✓		Vern	
1.328	+/-0.010	1.33	✓		Vern	
0.342	+/-0.010	0.340	✓		Vern	
0.740	+/-0.010	0.741	✓		Vern	
2.050	+/-0.010	2.047	✓		Vern	
0.040	+/-0.010	0.040	✓		Vern	
		N/A				
		See Last Page				
		EP 06/11/11				

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.08.12	New Issue		KJ/JLM	
B	06.11.24	Dwg Revision revised		KJ/JLM	
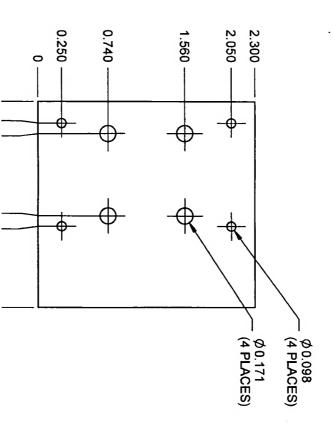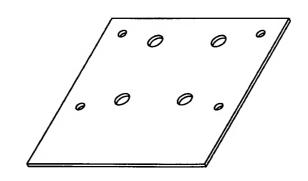
DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

	DRAWING NO.	REV. B
	D2151	SHEET 1 OF 1
TITLE	PACKER	

REV	DATE	DESCRIPTION
A	95.05.01	NEW ISSUE
B	06.10.13	UPDATE DRAWING

DESIGN	DRAWN BY
BW	CB
CHECKED	APPROVED
CE	
DATE	
06.10.13	

SCALE 1:1

D2151 PACKER

Dimensions (top view):
- 0
- 0.250
- 0.740
- 1.560
- 2.050
- 2.300

Vertical dimensions:
- 0
- 0.231
- 0.342
- 1.217
- 1.328
- 2.194

Ø 0.098 (4 PLACES)

Ø 0.171 (4 PLACES)

RELEASED
06.11.20

NOTES:
1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article   [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 -.001	.99	X			
Ø .171	+.005 -.001	.174	X			
.250	+/- .010	.250	X			
.740	+/- .010	.740	X			
1.560	+/- .010	1.560	X			
2.050	+/- .010	2.050	X			
2.300	+/- .010	2.300	X			
.231	+/- .010	.231	X			
.342	+/- .010	.342	X			
1.217	+/- .010	1.219	X			
1.328	+/- .010	1.328	X			
2.194	+/- .010	2.195	X			
.040	+/- .010	.040	X			

Measured by: PB	Audited by:	Prototype Approval: N/a
Date: 07-09-11	Date: 07/09/11	Date: N/a

Rev	Date	Change			Revised by	Approved
A		New Issue			KJ/JLM	